

What is claimed is:

1. A plant layout method for a foundry plant comprising the steps of:

arranging a multi-story warehouse (1) in a central portion
5 of said plant, said warehouse (1) being provided with a stacker crane (4, 4a) and a plurality of storage portions (4, 5, 6, 7, 45) for storing therein a core pattern (), a core, an empty one of completed molds before subjected to a melt pouring operation and a filled one of said completed molds after subjected to said melt pouring
10 operation;

arranging a mold making area (10) so as to extend along one of opposite outer sides of said multi-story warehouse (1), where a completed mold is prepared; and

arranging a casting processing area (11) so as to extend along
15 the other of said opposite outer sides of said multi-story warehouse (1) thereby performing in said casting processing area (11) a metal melting operation to prepare a melt, a melt pouring operation for pouring said melt into said completed mold, a cooling operation for cooling said completed mold filled with said melt, a flask
20 disassembling operation for disassembling said completed mold to obtain a casting therefrom, and a surface treating and a cleaning operation of said casting.

2. The plant layout method for the foundry plant as set forth
25 in claim 1, wherein at least one of said mold making area (10) and said casting processing area (11) has a two-story construction to provide a lower and an upper floor portion, said upper floor portion being formed into an area for making a main pattern, a core pattern

and a core.

3. The plant layout method for the foundry plant as set forth in claim 2, wherein said lower floor portion is formed into a plurality of areas for: storing therein a metal flask; making a main mold pattern; setting said core; and, mating a cope and a drag half of said mold.

4. A foundry plant comprising:

10 a multi-story warehouse (1) arranged in a central portion of said plant, said warehouse (1) being provided with a stacker crane (4, 4a) and a plurality of storage portions (4, 5, 6, 7, 45) for storing therein a core pattern (), a core, an empty one of completed molds before subjected to a melt pouring operation and a filled
15 one of said completed molds after subjected to said melt pouring operation;

a mold making area (10) extending along one of opposite outer sides of said multi-story warehouse (1), where a completed mold is prepared; and

20 a casting processing area (11), which extends along the other of said opposite outer sides of said multi-story warehouse (1) to perform a metal melting operation to prepare a melt, a melt pouring operation for pouring said melt into said completed mold, a cooling operation for cooling said completed mold filled with said melt,
25 a flask disassembling operation for disassembling said completed mold to obtain a casting therefrom, and a surface treating and a cleaning operation of said casting.

5. The foundry plant as set forth in claim 4, wherein at least

one of said mold making area (10) and said casting processing area (11) has a two-story construction to provide a lower and an upper floor portion, said upper floor portion being formed into an area for making a main pattern, a core pattern and a core.

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6. The foundry plant as set forth in claim 5, wherein said lower floor portion is formed into a plurality of areas for: storing therein a metal flask; making a main mold pattern; setting said core; and, mating a cope and a drag half of said mold.

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